












Date: Thursday, 23/04/2009 3:30:24 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSY (LH)
Job Number : 47438	
Estimate Number : 13285	
P.O. Number :	Part Number : D3699041 BK
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D3699 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44850	Material :
Written By :	Due Date : 10/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09-04-24</u>	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M6061T6S050 6061-T6 .050 Sheet
	
	
Comment: Qty.: 0.4797 sf(s)/Unit Total: 4.7975 sf(s) 6061T6 aluminium sheet .050" thick (M6061T6S050) Batch: <u>110791</u> B 9-5-26	
2.0	WATER JET FLOW WATER JET
	
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3699 Dwg Rev: <u>A</u> B 9-5-26 Prog Rev: <u>A</u> ***grain direction along 9.00" *** 2- Deburr if necessary B 9-5-26	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	
	
Comment: SECOND CHECK S 09/05/26 (12)	
5.0	BRAKE NC NC BRAKE
	
	
Comment: NC BRAKE Bend as per Dwg D3697 SB 09/05/26 (12)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 47438

Part Number: D3699041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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(-1)

Comment: INSPECT WORK TO CURRENT STEP

509/5/26

(12)

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3699

8.0	QC5	INSPECT WORK TO CURRENT STEP
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(-1)

Comment: INSPECT WORK TO CURRENT STEP

502/5/27

(12)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(12)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP 09/05/27

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 2:25pm

OVEN TEMPERATURE: 370°C

FINISH TIME: 2:50pm

91 09-05-27 FAL

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FAL 09/07/27

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0	MS21059L3	Nut Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut Plate

batch: M109962

509/5/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:24 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 47438

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

M 7681

09/05/28

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

09/05/28

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/28

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57205

09/05/28 (12)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28

Job Completion



MF 09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47438
Description: Support, LH		Part Number: D3699-1
Inspection Dwg: D3699 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

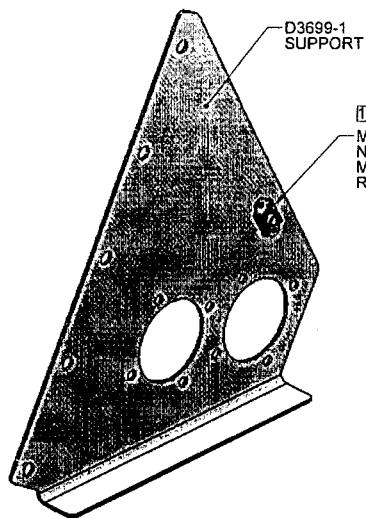
☒ **First Article**

 ☐ **Prototype**

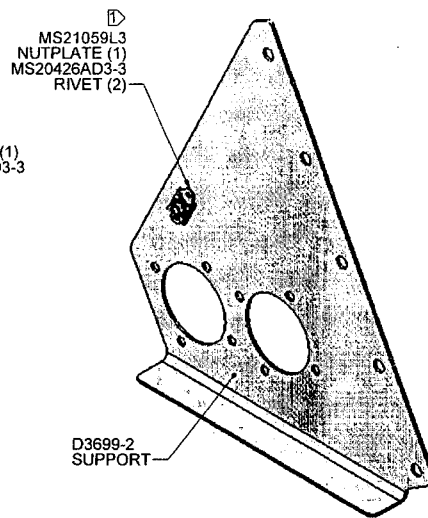
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099				
Ø0.180	+0.005/-0.001	.181				
Ø0.238	+0.005/-0.001	.240				
Ø1.525	+0.012/-0.001	1.524				
0.36	+/-0.030	.361				
0.62	+/-0.030	.621				
0.96	+/-0.030	.964				
2.21	+/-0.030	2.212				
4.12	+/-0.030	4.121				
8.95	+/-0.030	8.953				
1.925	+/-0.010	1.922				
8.61	+/-0.030	8.618				
2.62	+/-0.030	2.626				
0.344	+/-0.010	.344				
0.688	+/-0.010	.686				
0.64	+/-0.030	.64				
2.66	+/-0.030	2.661				
5.75	+/-0.030	5.749				
6.41	+/-0.030	6.396				
0.300	+/-0.010	.300				
0.923	+/-0.010	.923				
0.050	+/-0.010	.049				

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-26	Date: 09/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	



D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

PART LIST

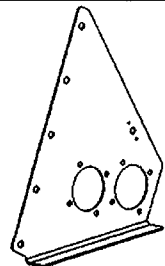
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

NO 111382
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

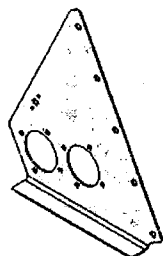
- NOTES:**
 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\phi 0.098$ HOLES ON D3699-1/-2
 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
 3) WEIGHT: 0.17 lb EACH

RELEASED
08-07-08

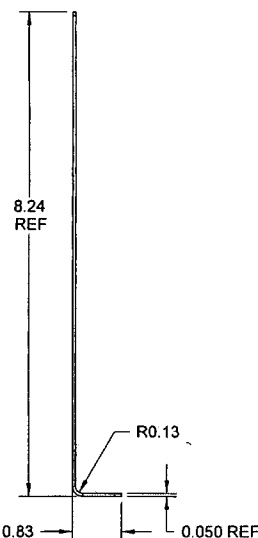
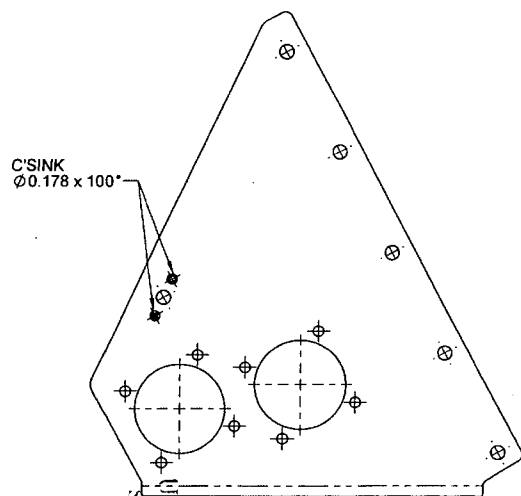
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JF		
CHECKED	SP	DRAWING NO.	REV. A
MFG. APPR.	SP	D3699	SHEET 1 OF 2
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3699-1 LH SUPPORT

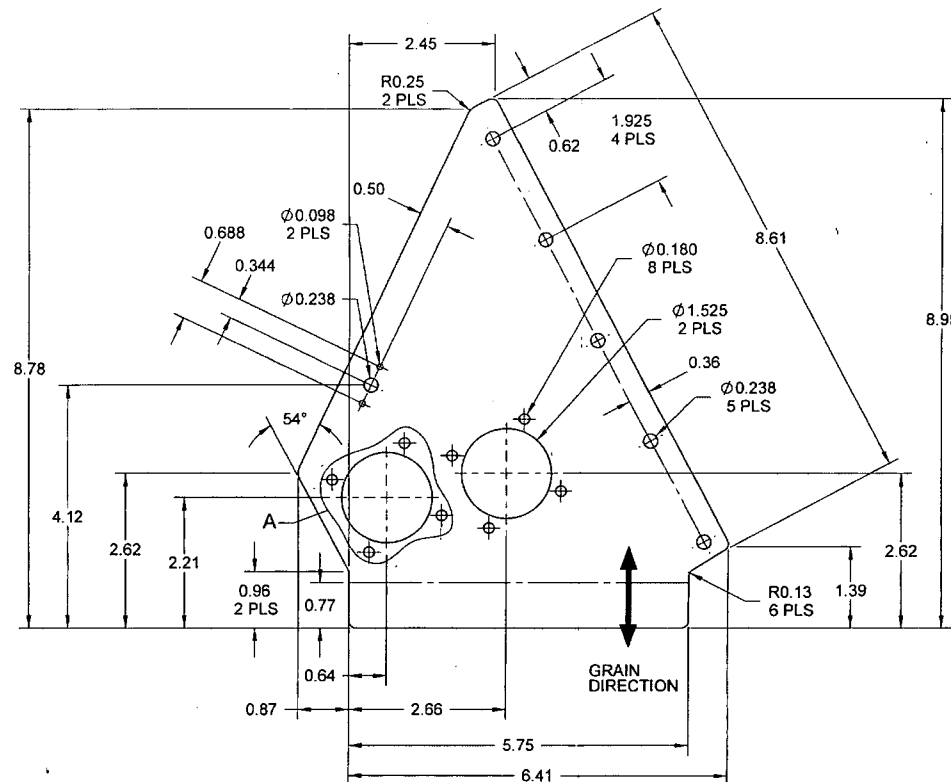


D3699-2 RH SUPPORT

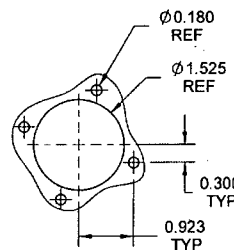


**D3699-1 SUPPORT, LH SHOWN
D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**

- NO. 12
WORK IN PROGRESS
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED
RETURN TO
ENGINEERING
SHOP COPY
MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK
(REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.17 lbs





D3699-1F FLAT PATTERN



DETAIL A

RELEASED
08-07-08

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3699	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
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